1	2	3	4	5	6

DRG. No. R201/A0/3250 SHEET No. - OF - SHEETS

DIMENSIONS IN INCHES UNLESS OTHERWISE STATED

√ INDICATES A MACHINED SURFACE N8 √ INDICATES THE MAXIMUM PERMITTED ROUGHNESS OF A MACHINED SURFACE

COMPARISON OF SURFACE ROUGHNESS VALUES

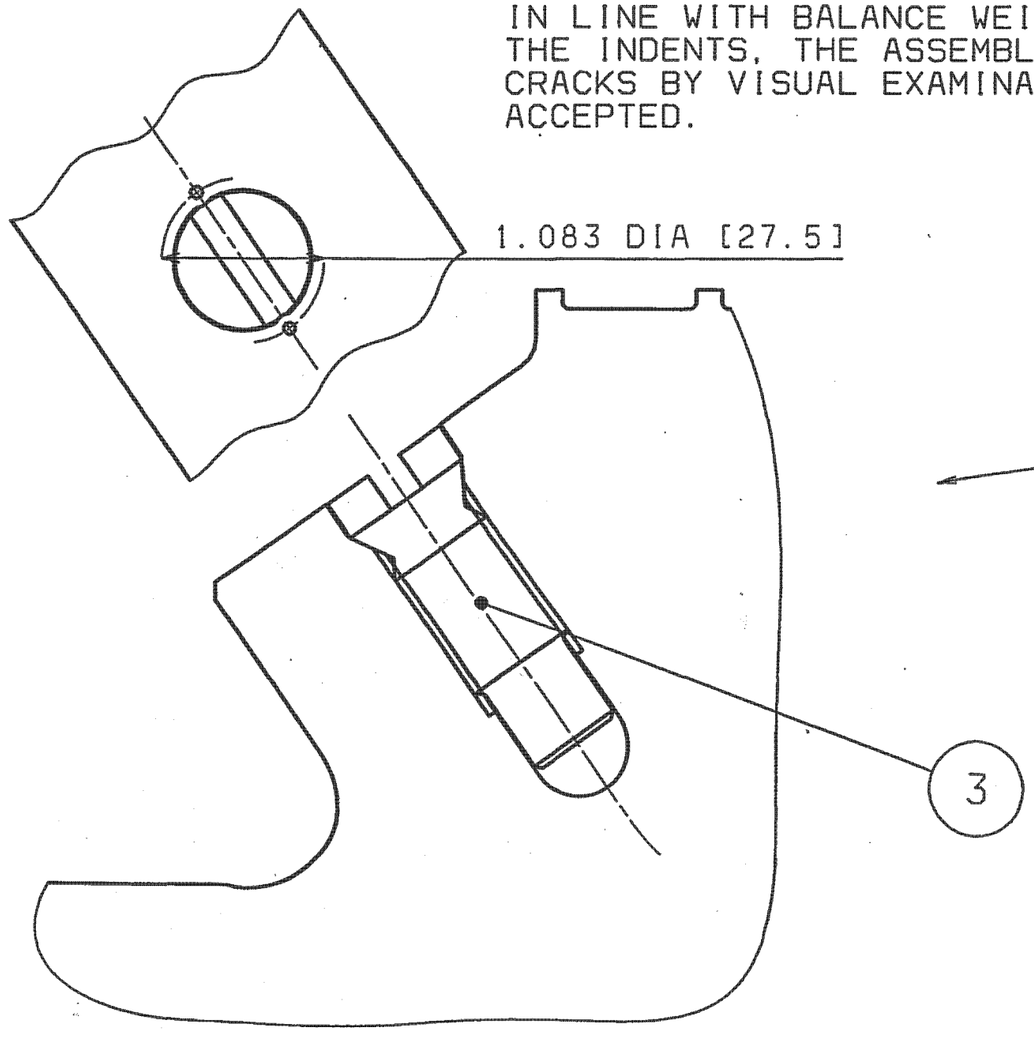
Nominal value	micrometre	12.5	6.3	3.2	1.6	0.8	0.4	0.2
	microinch	500	250	125	63	32	16	8
Roughness number		N10	N9	N8	N7	N6	N5	N4

PERMISSIBLE VARIATIONS OF UNTOLERANCED MACHINING DIMENSIONS. TOLERANCES ARE NOT TO BE CUMULATIVE

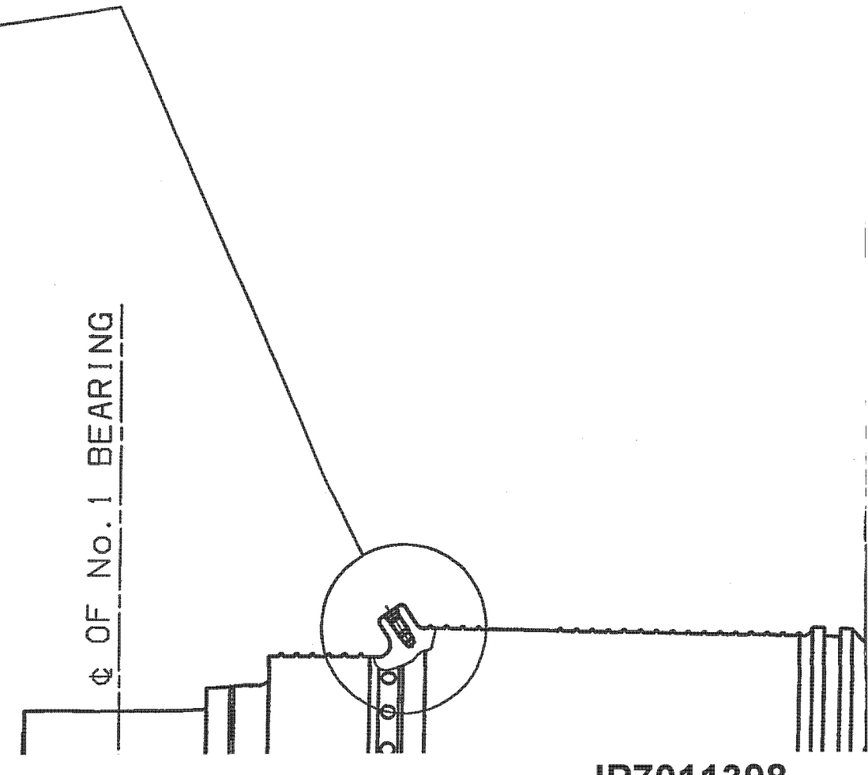
APPLICATION	IMPERIAL DIMENSIONS	METRIC DIMENSIONS
Bores, slots and recess depths, internal widths and lengths, external chamfers and radii.	+.010"	+0.2mm
Shaft diameter, spigot heights, external widths and lengths, internal chamfers and radii	-.010"	-0.2mm
Centre distances and centres to faces	±.030"	±0.8mm

ALL DIMENSIONS SHOWN THUS [] ARE IN M

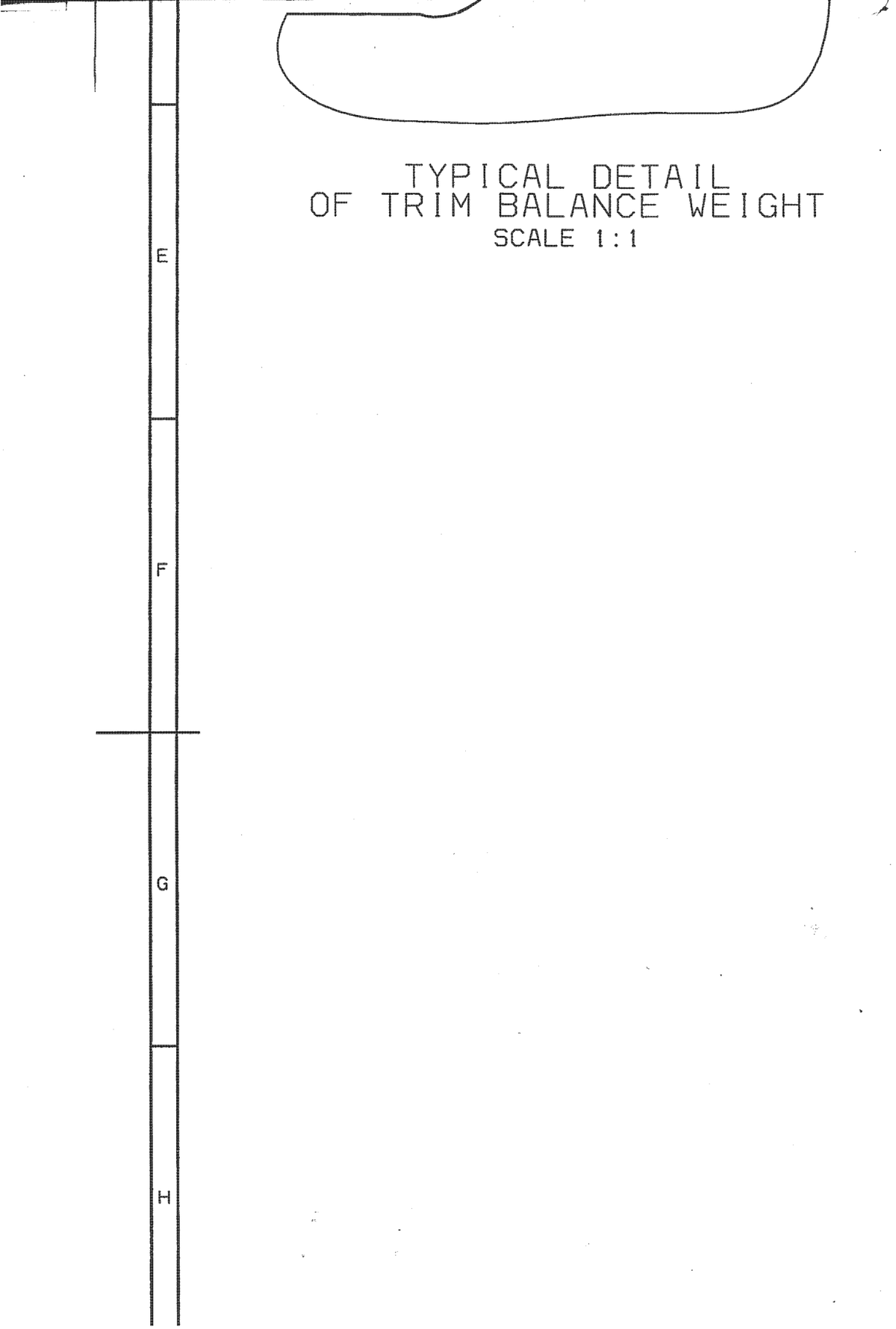
BALANCE WEIGHT TO BE SECURED TO THE ROTOR BY TWO EQUI-SPACED INDENTS PRODUCED BY A .08 DIA [Ø2] SPHERICAL ENDED TOOL. INDENTS ARE TO BE IN LINE WITH BALANCE WEIGHT SLOT. AFTER FORMING THE INDENTS, THE ASSEMBLY IS TO BE INSPECTED FOR CRACKS BY VISUAL EXAMINATION. NO CRACKS TO BE ACCEPTED.



TYPICAL DETAIL OF TRIM BALANCE WEIGHT

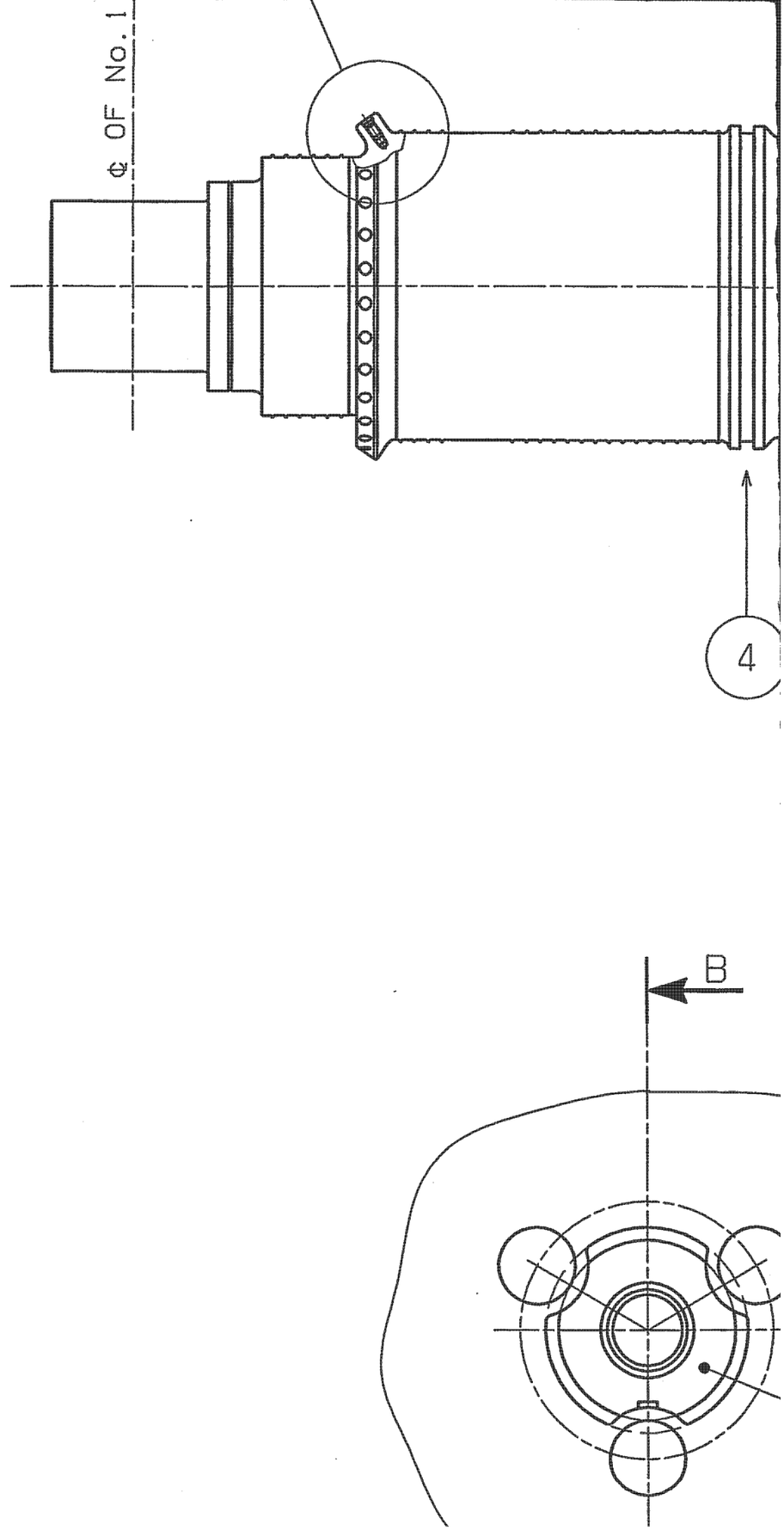


IP7011398



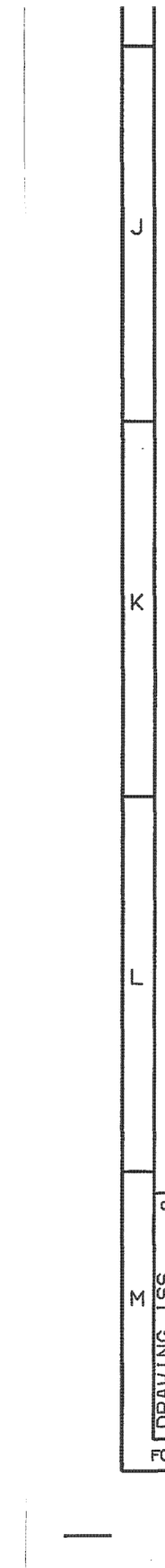
TYPICAL DETAIL
OF TRIM BALANCE WEIGHT
SCALE 1:1

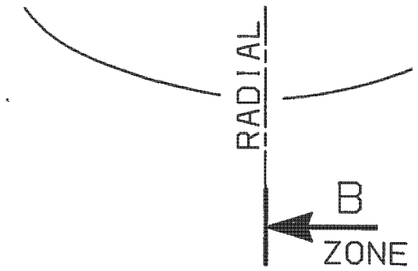
FRONT END



IP7011399

IP7011400





TYPICAL VIEW ON A
ZONE D-9
SCALE 5:1

CAD No.	A	B
DRAWING. ISS R201/A0/3250_B	ORIGINAL ISSUE	ISSUE
	DATE 22.06.01	DATE 18.2.03 SLH RJC

ON DRG ZONE A/C-11/13 PHASE ANGLE MARKER DETAILS, REFS 12 & 13. AND ASSOCIATED VIEWS ADDED. IN TABLE ZONE D-14 REF 13 ADDED. FOR INTERMOUNTAIN 760R0529/02/001/ 103/006 T11246 & FUT.
R TOWNSEND

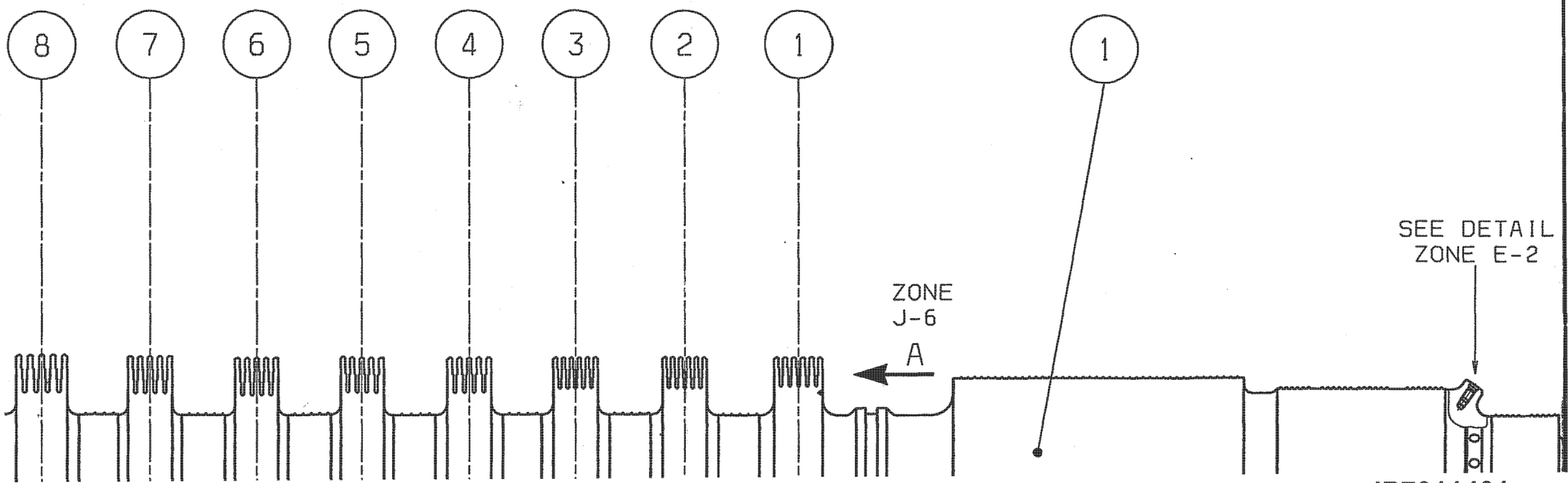
FORM LIB.F.A0-3C-MM DRAW 1

	7	8	9	10	11

MILLIMETERS

PEEN TO
TO DIMS S
ON ASSE

.040 [1.01]



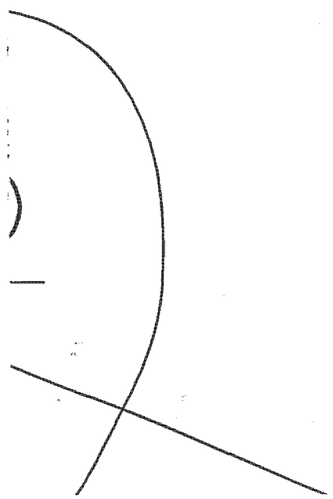
IP7011401

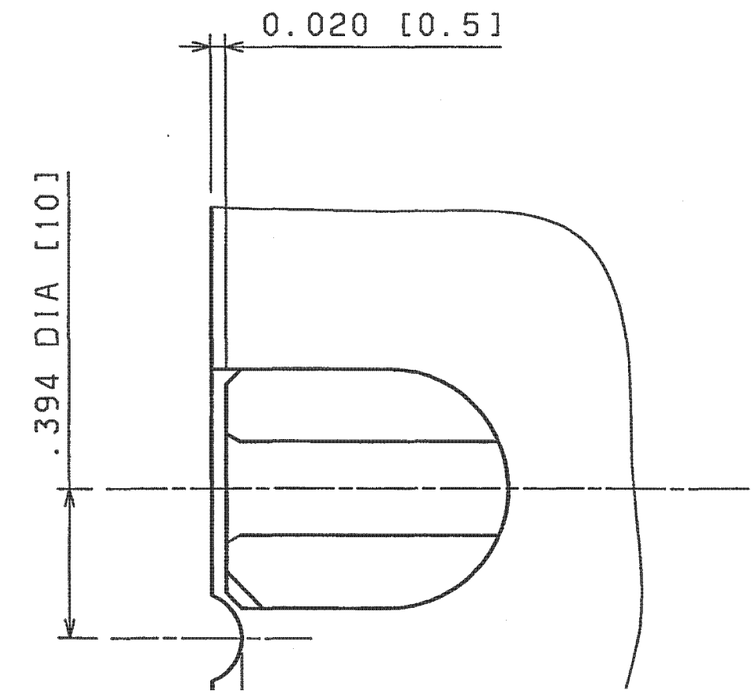
ZONE
J-6

A

(5)(6)(7) * SEE NOTE
ZONE B-14/15

(4)(5)(6)(7) * SEE NOTE
ZONE B-14/15





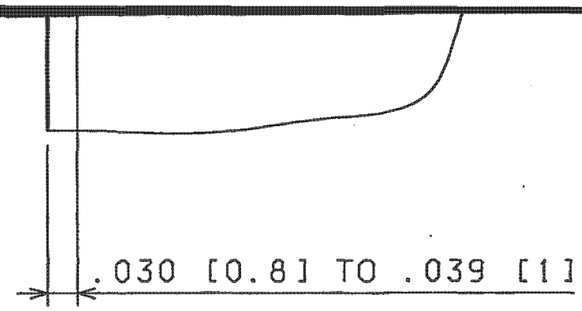
IP7011402

2

TO BE POSITIONED WITH
NOTCH ON THE RADIAL
LINE AND INBOARD AS
SHOWN

J-9/10

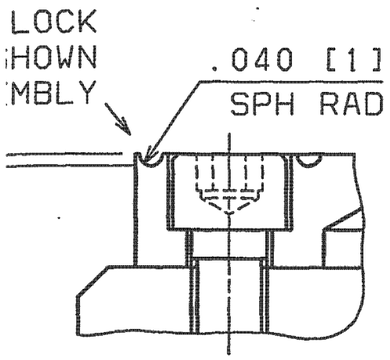
RROW A



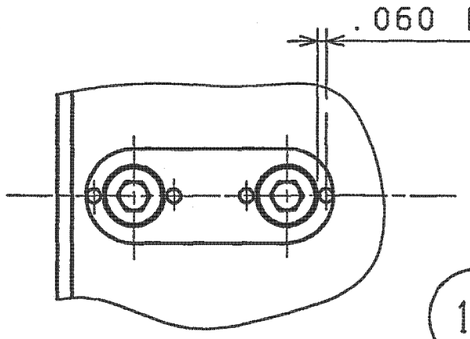
SECTION B-B
ZONE J-6

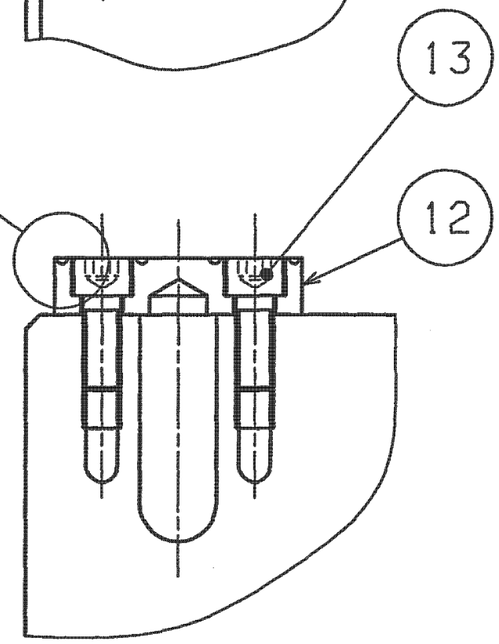
PLUG TO BE SECURED INTO THE DISC
BY THREE EQUI-SPACED INDENTS PRODUCED
BY A .120 [Ø3] SPHERICAL ENDED TOOL.
ONE OF THE INDENTS TO BE ON THE DISC
RADIAL LINE WHICH PASSES THROUGH THE
CENTRE OF THE PLUG AND IS TO COINCIDE WITH
THE ANTI-ROTATION NOTCH. THIS INDENT IS TO
BE ON THE INBOARD SIDE OF THE PLUG.
AFTER FORMING THE INDENTS, THE ASSEMBLY
IS TO BE INSPECTED FOR CRACKS BY VISUAL
EXAMINATION. NO CRACKS TO BE ACCEPTED..

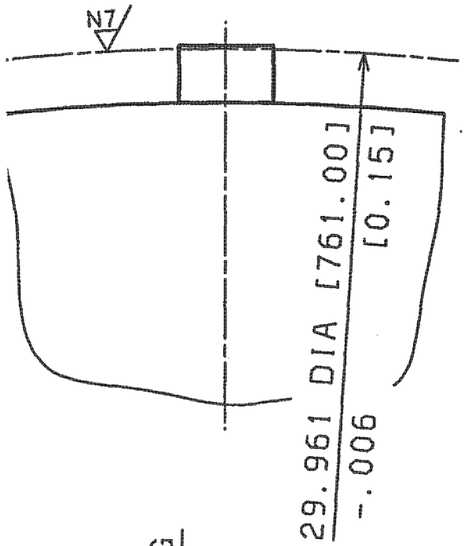
IP7011403



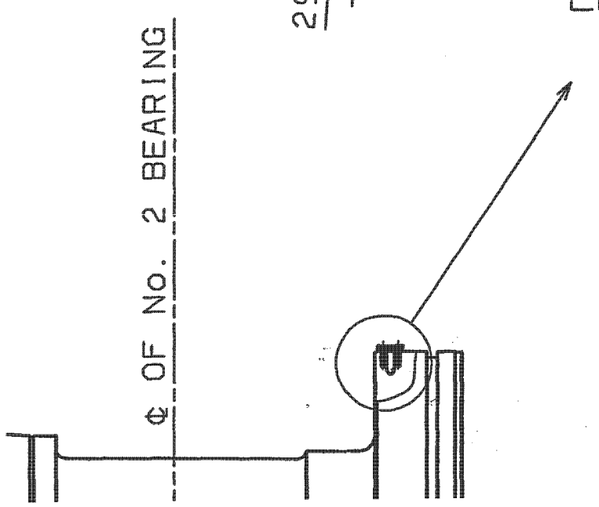
ENLARGED DETAIL
SCALE 2:1







ENLARGED DETAIL
SCALE 1:1



NOTES :-

FOR INFORMATION ON SPARE BALANCE WEIGHTS SEE R201/A3/3255

FOR ASSEMBLY AND PEENING OF BALANCE WEIGHTS SEE R201(A2)2760

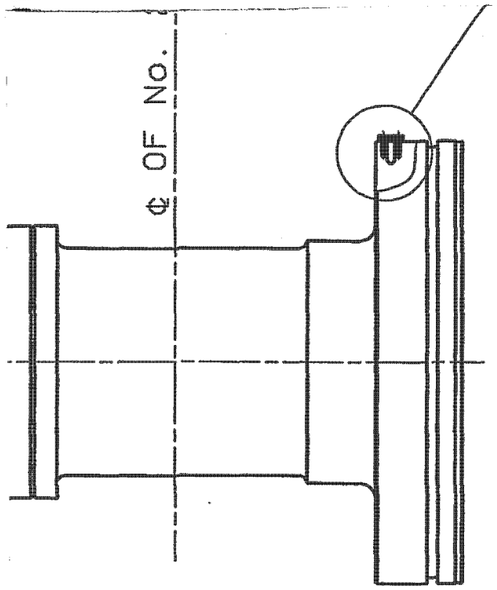
CARE TO BE TAKEN TO ENSURE THAT ONLY IMPERIAL THREAD BALANCE WEIGHTS BE USED IN ROTOR BALANCING - SEE PARTS LIST.

*BALANCE AND OVERSPEED OF ROTOR TO BE IN ACCORDANCE WITH GEC PROCESS SPEC 601/0020

NOTE

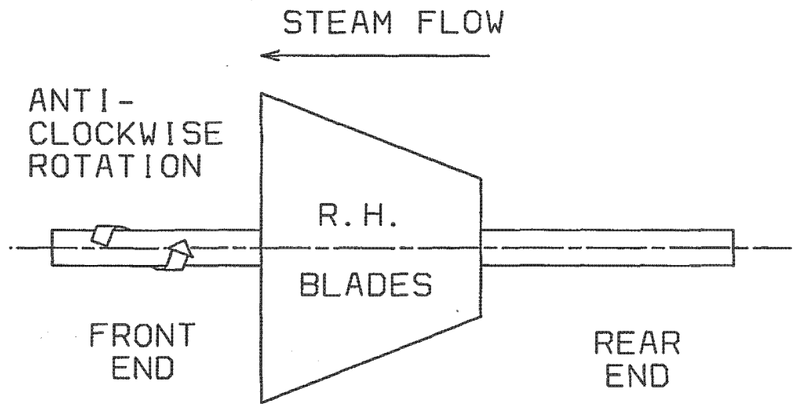
BEFORE ASSEMBLY ALL STUDS, BOLTS, NUTS, ETC ARE TO HAVE THREADS AND MATING SURFACES COATED WITH GREASE IN ACCORDANCE WITH CONTRACT REQUIREMENTS.
IN ADDITION ALL FASTENERS 3, 7 & 11 TO BE CONTROL TIGHTENED TO THE TORQUE LOADINGS GIVEN BELOW.

REF. NO.	SIZE	TORQUE	
		lb ft	Nm
3	3/4"-10UNC-2A	130	176
7	5/16"-18UNC-2A	8.5	11.5
11 & 13	1/4"-20UNC-2A	4.2	5.7



REAR END

8 9 10 11 * SEE NOTE ZONE B-14/15



BLADE DISPOSITION DIAGRAM

IP7011405

TITLE

HP ROTOR ASSEMBLY

THIRD ANGLE PROJECTION	DRAWN N. SEWELL	CHECKED S HALLARD	ALSTOM Energy Ltd. Steam Turbines Newbold Road Rugby CV21 2NH U.K.	ALSTOM
	TRACED	APPROVED R N C		
ORIGINAL SCALE 1:10	ISSUING DEPT T. E. G.		DRG. No. R201/A0/3250	SHEET No. - OF - SHEETS
	FIRST ORDER INTERMOUNTAIN 103/006			

DO NOT SCALE — WHEN QUOTING DRAWING NUMBER STATE LATEST ISSUE — SIZE A0

IP7011406